

Date: Thursday, 5/4/2006 11:14:35 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 26961	
Estimate Number : 12234	
P.O. Number : N/A	Part Number : D34807
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3480 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 26699	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/28/2006 Qty: 8 Um: Each
Checked & Approved By : <u>06.05.05</u>	
Comment : est rev. A 06/02/07 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MSIL60S125	high temp. silicone sheet .125
Comment: Qty.: 0.0554 sf(s)/Unit Total : 0.4435 sf(s) High temp. silicone sheet .125 batch: <u>M100105</u> <u>FF 06.05.18</u> 8		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Make as per dwg D3480 <u>FF 06.05.08</u> 8		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>SB 06/05/19</u> 8		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>57444</u> <u>06/15/23 (8)</u>		
5.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Inspection Level 21 <u>06/05/24</u> (8)		

Job Completion



06/05/24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *PD*   Date:   *06/05/24*    
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

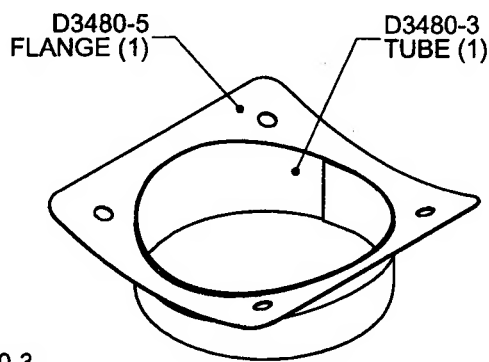
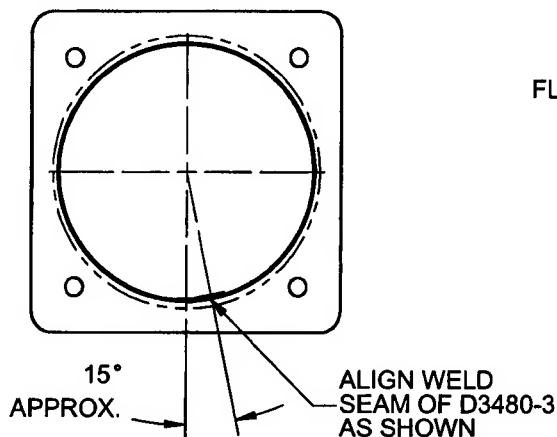
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

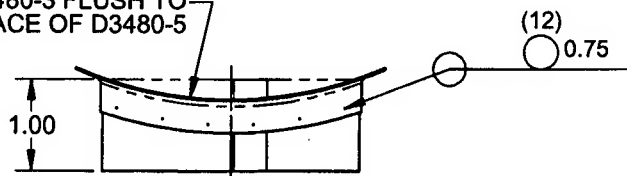
**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3480</b>	REV. A SHEET 1 OF 6
DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2
A	06.02.06	NEW ISSUE	

~~06.04.03~~



SPOT WELD PARTS, THEN  
CUT D3480-3 FLUSH TO  
SURFACE OF D3480-5



### **D3480-041 EYEBALL INLET ADAPTER**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26961

#### **NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

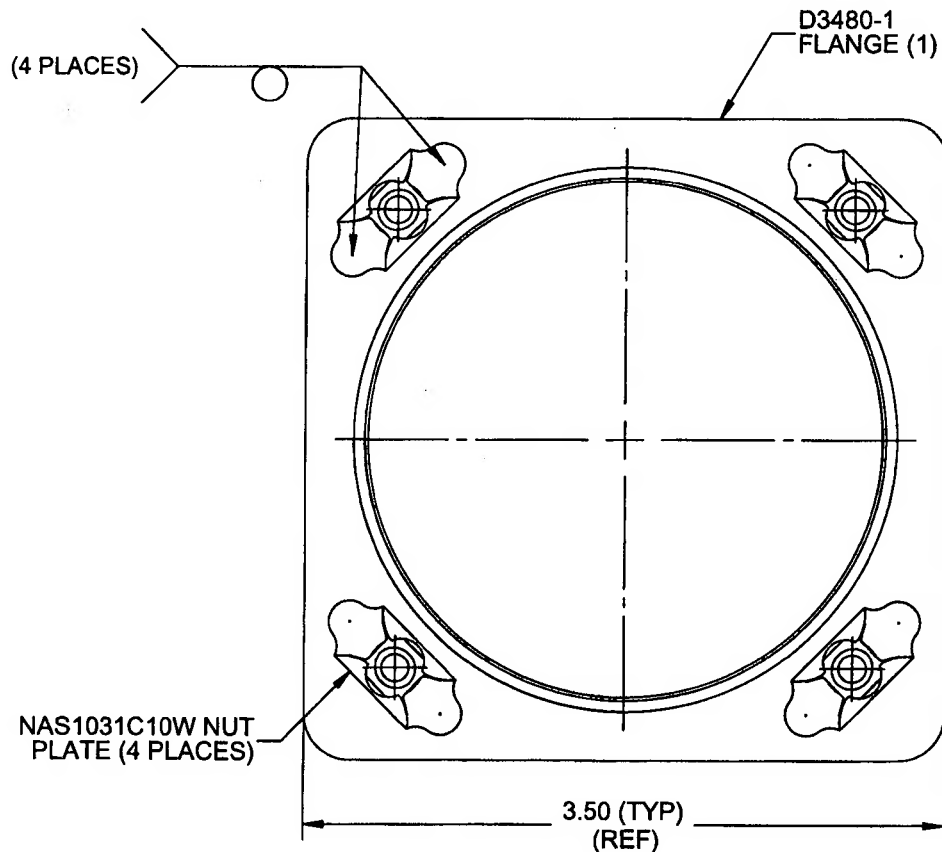
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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**DART**

DESIGN #3	DRAWN BY #3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #3	APPROVED #3	DRAWING NO. D3480	REV. A
DATE 06.02.06		TITLE EYEBALL ADAPTER	SHEET 2 OF 6 SCALE 1:1

**D3480-043 EYEBALL ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

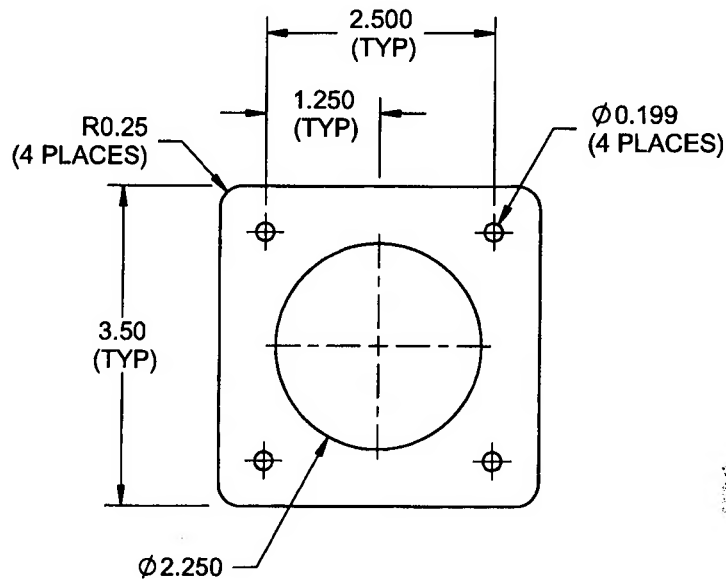
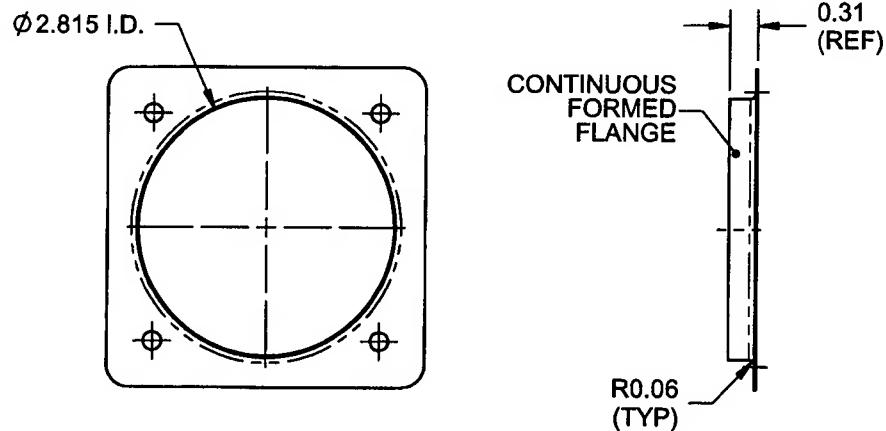
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2

**D3480-1F FLAT PATTERN****D3480-1 FLANGE**  
**(MAKE FROM D3480-1F)****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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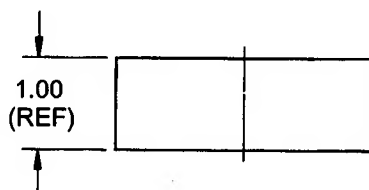
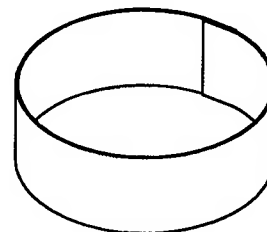
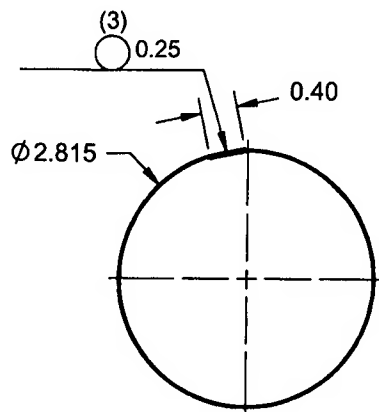
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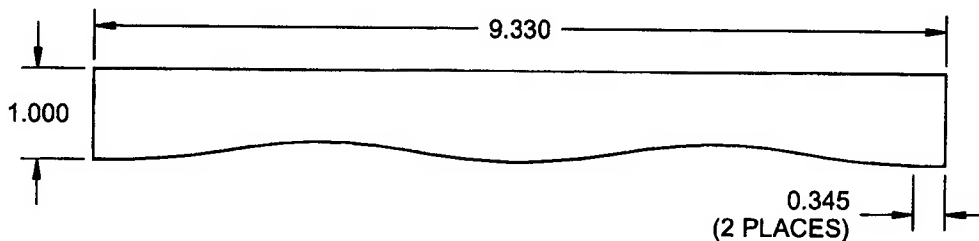
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



**D3480-3 TUBE**



**D3480-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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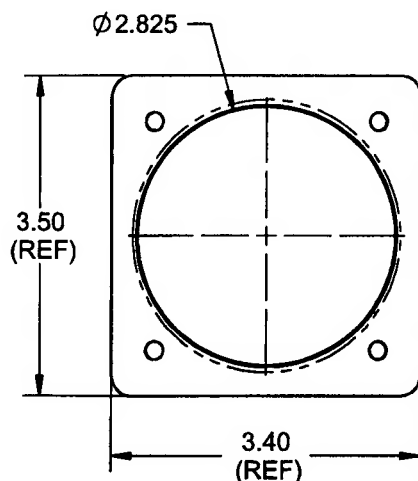
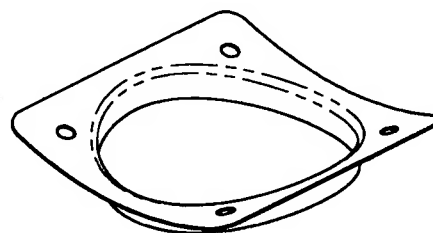
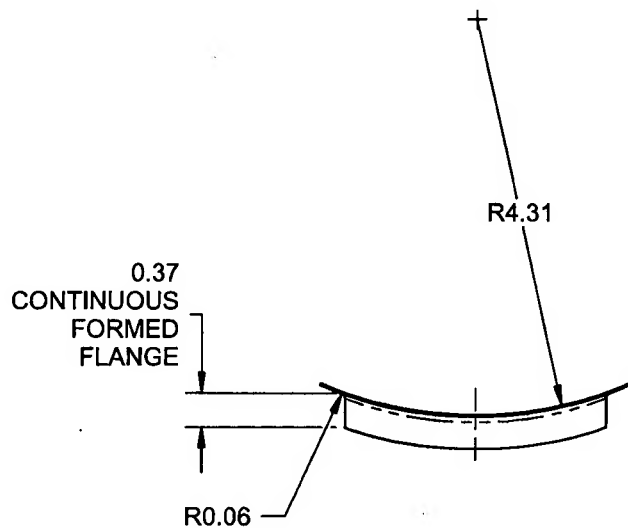
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2



*[Handwritten signature]* 06.04.03

### D3480-5 EYEBALL ADAPTER FLANGE

#### NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

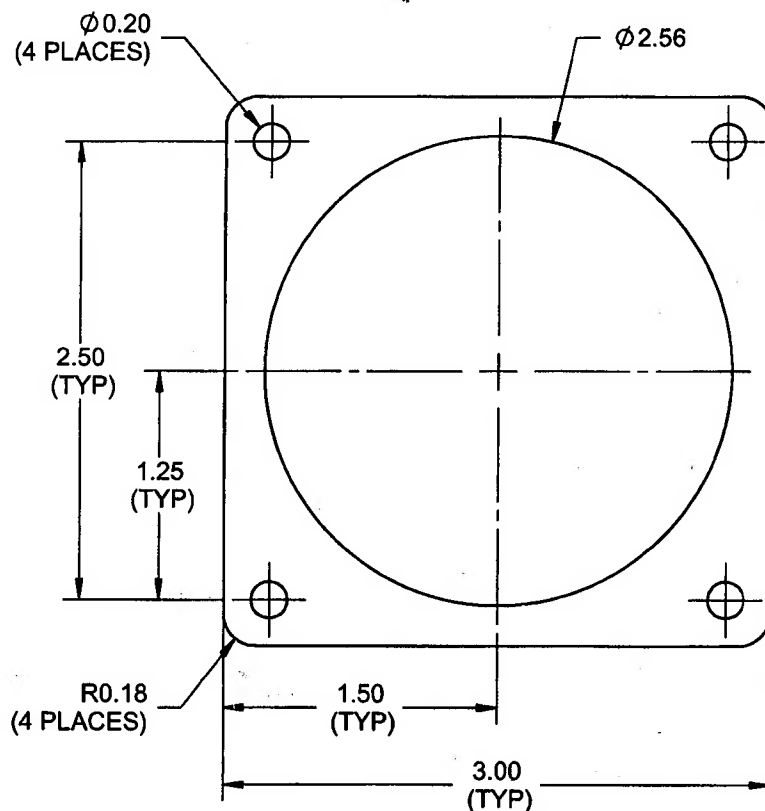
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:1

*[Signature]* 06.04.03**D3480-7 GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125) SUBJECT TO AMENDMENT WITHOUT NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Date: Wednesday, 5/24/2006 11:42:54 AM  
User: Chantal Lavoie

**INVENTORY ITEMS PICKED  
FOR SLIP NUMBER 2490**

**Project No.** : N/A  
**Customer** : Dart Helicopters Services  
**Part Number** : D34807  
**Job Number** : 26961

**Drawing Number** : D3480 REV.A  
**Drawing Name** : EYEBALL ADAPTER  
**Due Date** : / /  
**Qty** : 8  
**Slip #** : 2490

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 MSIL60S125 high temp. silicone sheet .125 Available 27.16	MAIN		ST343	100105		0.44	0.4400 sf